

1 4. A side gusseted poly bag with a filling valve
2 as defined in Claim 1, wherein the integral extension of the
3 forward and rear panels and adjacent gusset have a width of
4 about 30% of the width of the forward and rear panels.

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6 5. A side gusseted poly bag with a filling valve
7 as defined in Claim 4, wherein the integral extensions of
8 the forward and rear panels and adjacent gusset have a
9 height of about 30% of the width of the bag.

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11 6. A side gusseted poly bag with a filling valve
12 as defined in Claim 1, wherein the filling opening is
13 diagonal at said corner and the filling panel is defined at
14 least in part by portions of the forward and rear panels and
15 adjacent gusset at said corner folded inwardly into the bag.

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17 7. A side gusseted poly bag with a filling valve
18 as defined in Claim 6, wherein the gusset at the corner is
19 folded downwardly into the bag interior against the remain-
20 ing upper adjacent gusset forming an interior gusset defin-
21 ing a portion of the filling tube.

1 8. A side gusseted poly bag with a filling valve
2 as defined in Claim 1, wherein the upper portion of the
3 filling tube is defined by portions of the forward and rear
4 panels and the lower portion of the filling tube is defined
5 by portions of the adjacent gusset.

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7 9. A method for making a side gusseted poly bag
8 with a filling valve, including the steps of: forming a
9 tubular body of thermoplastic material having opposed side
10 gussets defining forward and rear main panels, heat sealing
11 the forward and rear panels together with the gussets along
12 a top portion and a bottom portion of the poly bag except at
13 one corner of the poly bag where the front panel is not con-
14 nected to the rear panel defining a filling opening in the
15 poly bag, forming a filling panel attached to the front and
16 rear panels extending into the bag interior along upper por-
17 tions of the front and rear panels, heat sealing the front
18 and rear panels with the filling panel forming a tubular
19 filling valve.

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21 10. A method for making a side gusseted poly bag
22 with a filling valve, including the steps of: feeding a web
23 tubular thermoplastic material, forming opposed side gussets
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1 in the tubular material, cutting the web transversely form-
2 ing bag preforms with top edges and an "L" shaped extension
3 from the top edges of the forward and rear panels and ad-
4 jacent gusset at one corner of the bag preform, folding the
5 extensions of the forward and rear panels and adjacent gus-
6 set inwardly against the interior surfaces of the forward
7 and rear panels with edges of the extension aligned with the
8 top edges of the forward and rear panels, and simultaneously
9 heat sealing the top edges of the forward and rear panels
10 along with the edges of the extensions forming the poly bag
11 with the filling valve.

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13 11. A method for making a side gusseted poly bag
14 with a filling valve as defined in Claim 11, wherein the
15 step of folding the extension of the forward and rear panels
16 and adjacent gusset inwardly includes folding portions of
17 the front and rear panels and adjacent gusset below the top
18 edges of the front and rear panel inwardly also along a
19 diagonal line from the top edges to the side of the front
20 and rear panels.